

Date: Friday, 10/10/2008 12:52:04 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT ASSY (RH)		
Job Number	: 42535			Part Number	: D3699042	
Estimate Number	: 13286			Drawing Number	: D3699 REVA	
P.O. Number	:			Project Number	: N/A	
This Issue	10/10/2008	S.O. No.	:	Drawing Revision	: A	
Prsht Rev.	: NC			Material	:	
First Issue	1 /	Type	SMALL /MED FAB	Due Date	31/10/2008	Qty: 2 Um: Each
Previous Run	: 41020					
Written By	:					
Checked & Approved By	: JUD 08.10.10					
Comment	: Est Rev:A 08-04-25 new issue DD verified by:ec					
	: Est Rev:B 08-07-14 revA as per dwg DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S050	6061-T6 .050 Sheet	
		Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.9595 sf(s) 6061T6 aluminium sheet .050" thick (M6061T6S050) Batch: 104186	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3699 Dwg Rev: A Prog Rev: A ***grain direction along 9.00" *** 2- Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Bend as per Dwg D3697	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/10/2008 12:52:04 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 42535

Part Number: D3699042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/10/23 (42)

Comment: INSPECT WORK TO CURRENT STEP

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(Ph)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D3699

INSPECT WORK TO CURRENT STEP

E 08/10/28 (5)

8.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(5X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/10/28

10.0 POWDER COATING

POWDER COATING



(5X)

M 10 S 642

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 7:20

01

OVEN TEMPERATURE: 320

0F

FINISH TIME: 7:30

m-1 08/10/31

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/10/31

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0 MS21059L3

Nut Plate



5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut Plate
batch:

M107479

AS 08/10/31 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3699-042 PAR #: N/A Fault Category: Prog - Sm. Red. NCR: Yes No DQA: H Date: 08/11/18
(D412-776-041) Resolution: Scrap Disposition: Scrap QA: N/C Closed: HJ Date: 08/11/20

NCR: 42535		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/27	# 7.0	Employee noticed after countersinking the first hole that it was on the wrong side.	8/10/27	Scrap and Destroy and Replace Qty ①	8/10/27	8/10/27	8/10/27	8/10/27
		Another employee was not paying attention to drawing.	8/10/27	606176 104186 ④ 8.050"	8/10/27	8/10/27	8/10/27	8/10/27
				④ Bend as per Drawing. Qty of 5	8/10/27	8/10/27	8/10/27	8/10/27

NOTE: Date & initial all entries

Date: Friday, 10/10/2008 12:52:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT ASSY (RH)
Job Number: 42535		Part Number: D3699042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
14.0	MS20426AD33	Rivet 10
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Rivet batch: M1563		 AS 08/10/31 x5
15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 E08/11/03 (S)
16.0	QC5	INSPECT WORK TO CURRENT STEP J08/11/03 (S)
17.0	PACKAGING 1	PACKAGING RESOURCE #1 G08/11/03 (S)
18.0	QC21	FINAL INSPECTION/W/O RELEASE 08/11/04 (S)
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 U 08/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	142535
Description: Support, RH	Part Number:	D3699-2
Inspection Dwg: D3699 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	X			
Ø0.180	+0.005/-0.001	.180	X			
Ø0.238	+0.005/-0.001	.238	X			
Ø1.525	+0.012/-0.001	1.530	X			
0.36	+/-0.030	.368	X			
0.62	+/-0.030	.624	X			
0.96	+/-0.030	.961	X			
2.21	+/-0.030	2.213	X			
4.12	+/-0.030	4.120	X			
8.95	+/-0.030	8.95	X			
1.925	+/-0.010	1.928	X			
8.61	+/-0.030	8.61	X			
2.62	+/-0.030	2.622	X			
0.344	+/-0.010	.344	X			
0.688	+/-0.010	.691	X			
0.64	+/-0.030	.660	X			
2.66	+/-0.030	2.66	X			
5.75	+/-0.030	5.760	X			
6.41	+/-0.030	6.43	X			
0.300	+/-0.010	.304	X			
0.923	+/-0.010	.925	X			
0.050	+/-0.010	.050	X			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	8-10-14	Date:	08/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	D

8

7

6

5

4

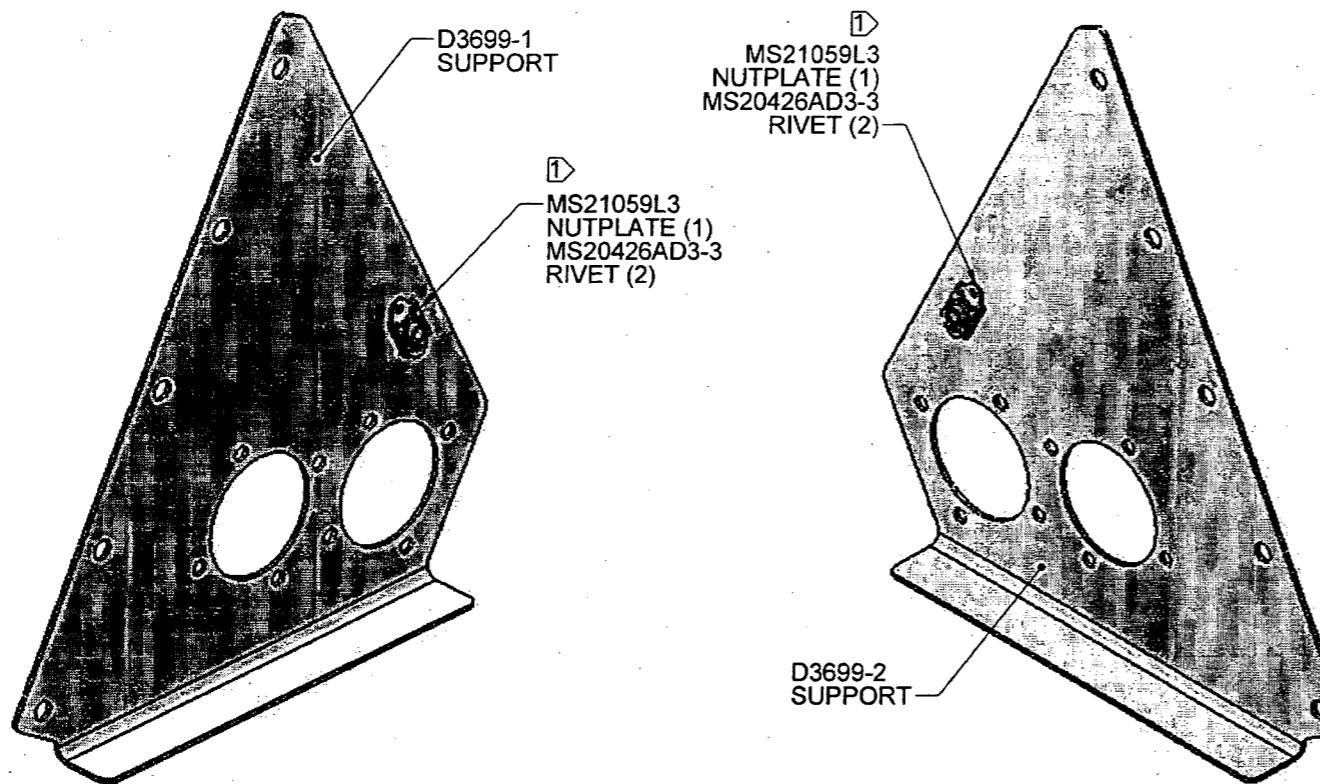
3

2

1

D

D

**D3699-041 SUPPORT ASSEMBLY****D3699-042 SUPPORT ASSEMBLY****PART LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

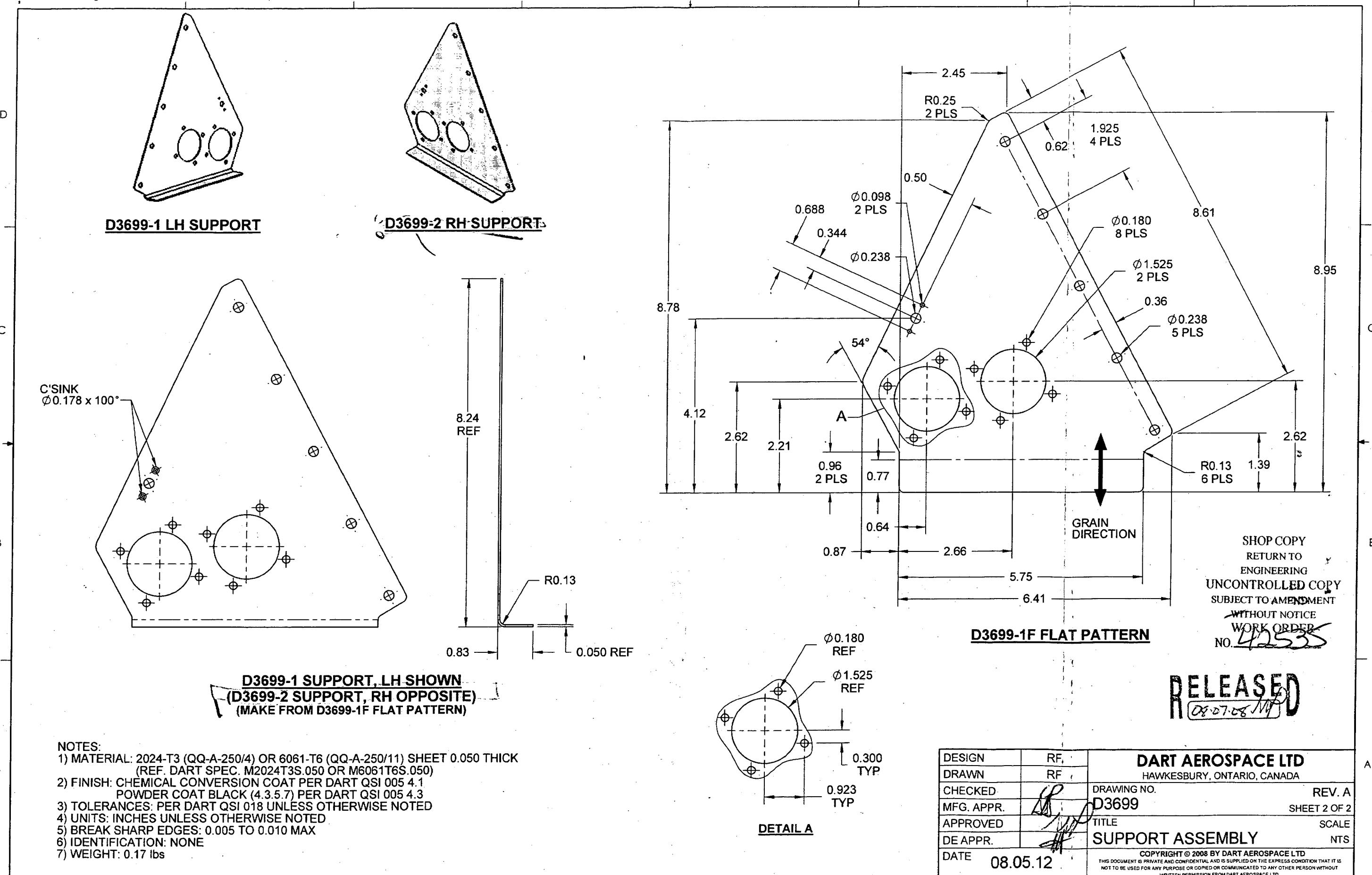
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42535

RELEASED
08.07.08 MTD

NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK ϕ 0.098 HOLES ON D3699-1/2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	77	DART AEROSPACE LTD	
DRAWN	77	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	AA	D3699	SHEET 1 OF 2
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DART AEROSPACE LTD

Work Order: 42535

Description: Support

Part Number: D3699-2

Inspection Dwg: D3699-2, Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .098	+ .004 - .001	.100	✗			
∅ .180	+ .005 - .001	.183	✗			
∅ .238	+ .005 - .001	.240	✗			
∅ 1.525	+ .012 - .001	1.529	✗			
.36	+/- .030	.368	✗			
.62	+/- .030	.624	✗			
.96	+/- .030	.961	✗			
2.21	+/- .030	2.213	✗			
4.12	+/- .030	4.120	✗			
8.95	+/- .030	8.95	✗			
1.905	+/- .010	1.908	✗			
8.61	+/- .030	8.61	✗			
2.62	+/- .030	2.622	✗			
.344	+/- .010	.344	✗			
.688	+/- .010	.691	✗			
.64	+/- .030	.66	✗			
2.66	+/- .030	2.66	✗			
5.75	+/- .030	5.760	✗			
6.41	+/- .030	6.43	✗			
.300	+/- .010	.304	✗			
.923	+/- .010	.925	✗			
.050	+/- .010	.050	✗			

Measured by:	B
Date:	8-10-27

Audited by:	S
Date:	06/10/27

Prototype Approval:	N/A
Date:	8-10-27

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	